

Sptit 2/2

Work Order ID 84091-2

Wednesday, May 02, 2012 1:12:13 PM

\*84091\*

Page 1

Item ID: D3537-1

Revision ID:

Item Name: Wearpad

Start Date: 5/2/2012 Start Qty: 50.00

Required Date: 5/8/2012 Req'd Qty: 50.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date: 12-05-2 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

\*100\*

Waterjet

FLOW CNC Waterjet

304 063

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr  
if necessary

B/L 5-15

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B/L 5-15

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Dr. 10-15

cont  
(260)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84091

Wednesday, May 02, 2012 1:12:13 PM

**\*84091\***

Page 2

Item ID: D3537-1

Accept

Revision ID:

Item Name: Wearpad

Start Date: 5/2/2012 Start Qty: 50.00

Required Date: 5/8/2012 Req'd Qty: 50.00

Reference:

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

130

**\*130\***

Brake NC

Brake NC

Operation  
Description

NC BRAKE

Memo

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-  
Identify as D3537-1

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

**\*140\***

Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat  
12/18/02 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any  
weld that penetrated through Wearpad if necessary

0.00

0.00

QC10- Inspect visual per QSI004- ground welds

0.00

150

**\*150\***

QC

Quality Control

Memo

0.00

(X18)

MAL

12/05/30

(X18)

5/2/05/30



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84091

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**\*84091\***

Page 3

Item ID: D3537-1

Accept

Revision ID:

**\*N900040100\***

Setup Start **\*NS1\***

Item Name: Wearpad

Stop **\*NS2\***

Start Date: 5/2/2012 Start Qty: 50.00

**\*50\***

Required Date: 5/8/2012 Req'd Qty: 50.00

**\*50\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

8/2/05/30

(416)

QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005-4.3

0.00

**\*170\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30

OVEN TEMPERATURE:

3200 F FINISH TIME:

12:00

18X ✓

mf  
12/06/04

m121279

180

QC3- Inspect Part Finish

0.00

**\*180\***

QC

Memo

0.00

Quality Control

18 ✓

BL12-6-4E



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 84091**

Wednesday, May 02, 2012 1:12:14 PM

**\*84091\***

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Item ID: D3537-1

Revision ID:

Item Name: Wearpad

Start Date: 5/2/2012

Required Date: 5/8/2012

Reference:

Start Qty: 50.00

Req'd Qty: 50.00

**\*50\*****\*50\***

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg &amp; Stock Location:

*FR 2*

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

*12/6/6**112-065*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 02, 2012 1:12:19 PM

Page 1

Work Order ID: 84091

Parent Item: D3537-1

Parent Item Name: Wearpad

\*84091\*

\*D3537-1\*

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	94.3720	0.106	5.578947	(60)	7	

\*M304S16GA\*

304/316 Sheet .063

\*\*

181 2-5-15

## Location

MAT020

120866

120877

## Loc Qty

94.372

14.246

80.126

## Loc Code

121622

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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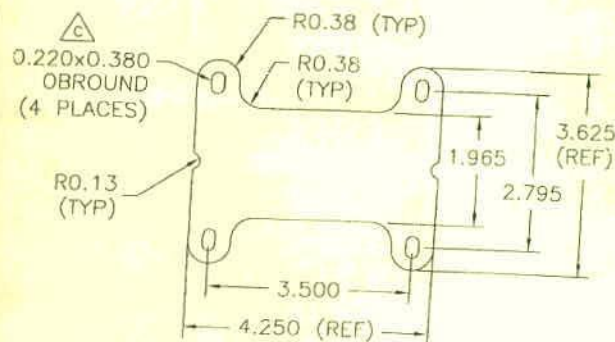




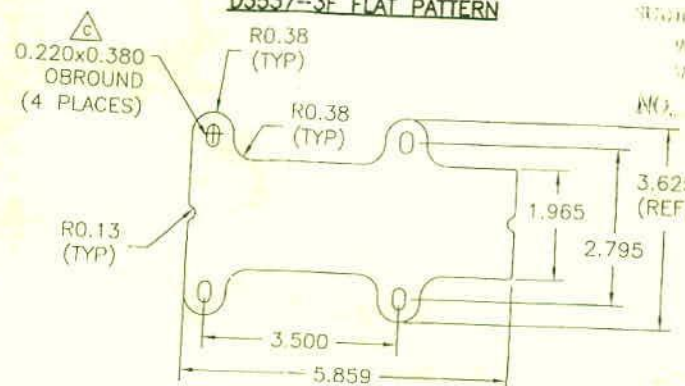




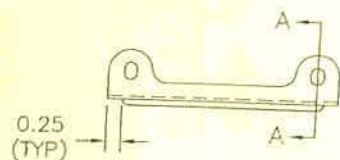
### D3537-1F FLAT PATTERN



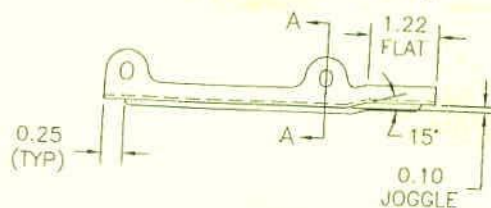
### D3537-3F FLAT PATTERN



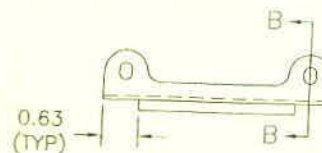
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

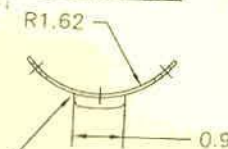


### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

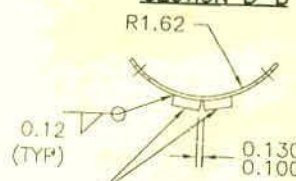
UNCONTROLLED  
REVISIONS  
84094  
1/12/05

### SECTION A-A



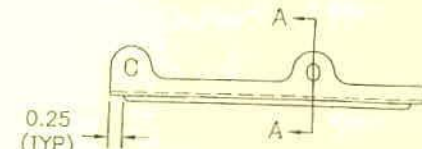
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

### SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



UNDER REVIEW  
07-05-08 AH  
per ECN 962

RELEASED

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DESIGN	C.B.	DRAWN	J.T.
CHECKED	#	APPROVED	#
DATE	07.04.13	DRAWING NO.	D3537
		TITLE	WEARPAD
		REV. C	SHEET 1 OF 1
		SCALE	1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries